

ACTEGA Kelstar

UV Coating Troubleshooting Guide

TROUBLESHOOTING GUIDE FOR UV COATINGS

PROBLEM	CAUSE	CORRECTIVE ACTION
Gloss	Low coating film weight.	Increase coating volume.
	Poor coating flow.	Contact your ACTEGA Kelstar representative.
	Coating not sufficiently cured.	Increase energy, check lamps and reflectors.
	Substrate too absorbent.	Contact substrate supplier.
	Coating drying back into ink or primer.	Provide adequate drying prior to coating.
	Excessive spray powder on sheet.	Decrease spray powder usage / use crusher.
Leveling	Inadequate mixing of coating.	Mix coating prior to and during use.
	Wax or silicone in inks.	Contact your ACTEGA Kelstar representative.
	Coating not mixed prior to use.	Mix coating prior to and during use.
	Incorrect coating viscosity.	Contact your ACTEGA Kelstar representative.
	Coating film weight too high.	Decrease coating volume.
	Excessive spray powder on sheet.	Decrease spray powder usage / use crusher.
	Substrate surface energy too low.	Corona treat or contact substrate supplier.
	Poor substrate smoothness.	Contact substrate supplier.

Contact **ACTEGA Kelstar** at 856 829 6300 or info.actega.kelstar@altana.com for additional information or technical assistance.

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PROBLEM	CAUSE	CORRECTIVE ACTION
Intercoat Adhesion	Wax or silicone in inks.	Contact your ACTEGA Kelstar representative.
	Metallic pigment used.	Contact your ACTEGA Kelstar representative.
	Inks or primer not sufficiently dry.	Provide adequate drying prior to coating.
	Plasticizer migrating from substrate.	Contact substrate supplier.
	Improper exposure or cure of coating.	Provide proper cure or exposure.
	High oil absorption rate of substrate.	Contact substrate supplier or ACTEGA Kelstar representative.
Slip	Improper exposure or cure of coating.	Provide proper cure or exposure.
	Insufficient mixing / recirculation of coating.	Mix coating prior to and during use.
	Different surfactant package needed.	Contact your ACTEGA Kelstar representative
Abrasion Resistance	Wax or silicone in inks.	Contact your ACTEGA Kelstar representative.
	Metallic pigment used.	Contact your ACTEGA Kelstar representative.
	Inks or primer not sufficiently dry.	Provide adequate drying prior to coating.
	Plasticizer migrating from substrate.	Contact substrate supplier.
	Improper exposure or cure of coating.	Provide proper cure or exposure.
	Low coating film weight.	Increase coating volume.
	Excessive spray powder on sheet.	Decrease spray powder usage / use crusher.

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PROBLEM	CAUSE	CORRECTIVE ACTION
Cure	Improper exposure or cure of coating.	Provide proper cure or exposure.
	Substrate, Ink, primer inhibiting cure	Contact appropriate supplier
	Dirty Lamps or reflectors	Contact maintenance or equipment supplier
	Excessively aged lamps	Contact maintenance or equipment supplier
	Warped/improperly focused reflectors	Contact maintenance or equipment supplier
Flexibility	Excessive cure or exposure of coating	Provide proper cure or exposure
	Substrate has poor flexibility	Contact substrate supplier
	Poor intercoat adhesion	Contact your ACTEGA Kelstar representative
	Improper or insufficient scoring	Provide new dies or adequate scoring
	Coating has insufficient flexibility	Contact your ACTEGA Kelstar representative
	Excessive coating film thickness	Decrease coating volume
Color Shift	Inks contain alkali-sensitive pigments	Contact your ink supplier or ACTEGA Kelstar representative

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PROBLEM	CAUSE	CORRECTIVE ACTION
Blocking	Coating not sufficiently cured	Provide proper cure or exposure
	Excessive load temperature or pressure	Provide cooling, use smaller lifts
	Static from application equipment	Use anti-static device, contact ACTEGA Kelstar representative
	Static from environmental conditions	Use anti-static device, contact ACTEGA Kelstar representative
	Coating doesn't contain anti-static material	Contact your ACTEGA Kelstar representative
Foaming	Viscosity incorrect for application / equipment	Contact your ACTEGA Kelstar representative
	Static fountain being used	Recirculate coating from storage bin to equipment
	Coating not mixed prior to use	Mix coating prior to and during use
	Recirculation pump type incorrect	Use diaphragm-type or low-shear pump

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